

Work Order ID 46411-45/11+

June 26, 2009 11:51:08 AM



Page 1

Item ID: D6101-005

Accept



Setup Start



Revision ID: A

Stop



Item Name: Saddle Billet

Start Date: 15/07/2009 Start Qty: 300.00

150



Cust Item ID:

Customer:

Required Date: 03/08/2009 Req'd Qty: 300.00

Reference:

Approvals:

Process Plan:

CZ

Date: 09/10/28 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D6101

Rev A

100

0.00



Purchasing

PURCHASING

Memo

0.00

Purchasing

Issue P/O: 8373 a) Description: Aluminum billet b) 5.00" x 8.250" x 2.50" thick c) Tolerance on all dimensions are +0.030"/-0.000" d) Grain direction along 5.00" length e) Material: 7075-T7351 (QQ-A-250/12)

f) Material certification required

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure material certification is attached

CZ 09/10/23

09/14/23 (40)

250



# Work Order ID 46411

June 26, 2009 11:51:08 AM

Page 2

Item ID: D6101-005

Revision ID: A

Item Name: Saddle Billet

Start Date: 15/07/2009 Start Qty: 300.00

Required Date: 03/08/2009 Req'd Qty: 300.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
----------------	--------------	--------------	---------------	---------------	------------------	----------------

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

Ensure Material certification comply to Dwg D6101

*ml 09/10/24*

*40*

130

Identify as per dwg & Stock Location: *mat*

0.00



Packaging

Memo

0.00

Packaging

*ml 09/10/24*

*40*

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*09/10/24*  
*pl 09/10/26 (40)*



# Picklist Print

June 26, 2009 11:30:12 AM

Work Order ID: 46411

Parent Item: D6101-005RevA

Parent Item Name: Saddle Billet

Comments:



Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 300.00

Required Qty: 300.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-005PRevA		Purchased	No			110	Each	0.0000	300.0000			
7075-17351 8.25X5.0X2.5												



*15/07/2009* *90*





**Castle Metals®**

A. M. Castle &amp; Co.

**PACKING SLIP**

Page 1 of 1

Pack Slip No:4618359

<b>Ship From:</b> Castle Metals MONTREAL 835-SELKIRK AVENUE POINTE CLAIRE, QUEBEC H9R 3S2		<b>Sold To:</b> DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7		<b>Ship To:</b> DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7		<b>Deliver To:</b> DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
<b>Date Shipped</b> 21-OCT-09	<b>F.O.B.</b> ORIGIN	<b>Freight Terms</b> Prepaid		<b>Carrier</b> MANITOULIN	<b>BOL No</b> 99185-2	<b>Delivery No</b> 4618359	

<b>Shipment Details</b>	<b>Final Destination Branch - MON</b>
-------------------------	---------------------------------------

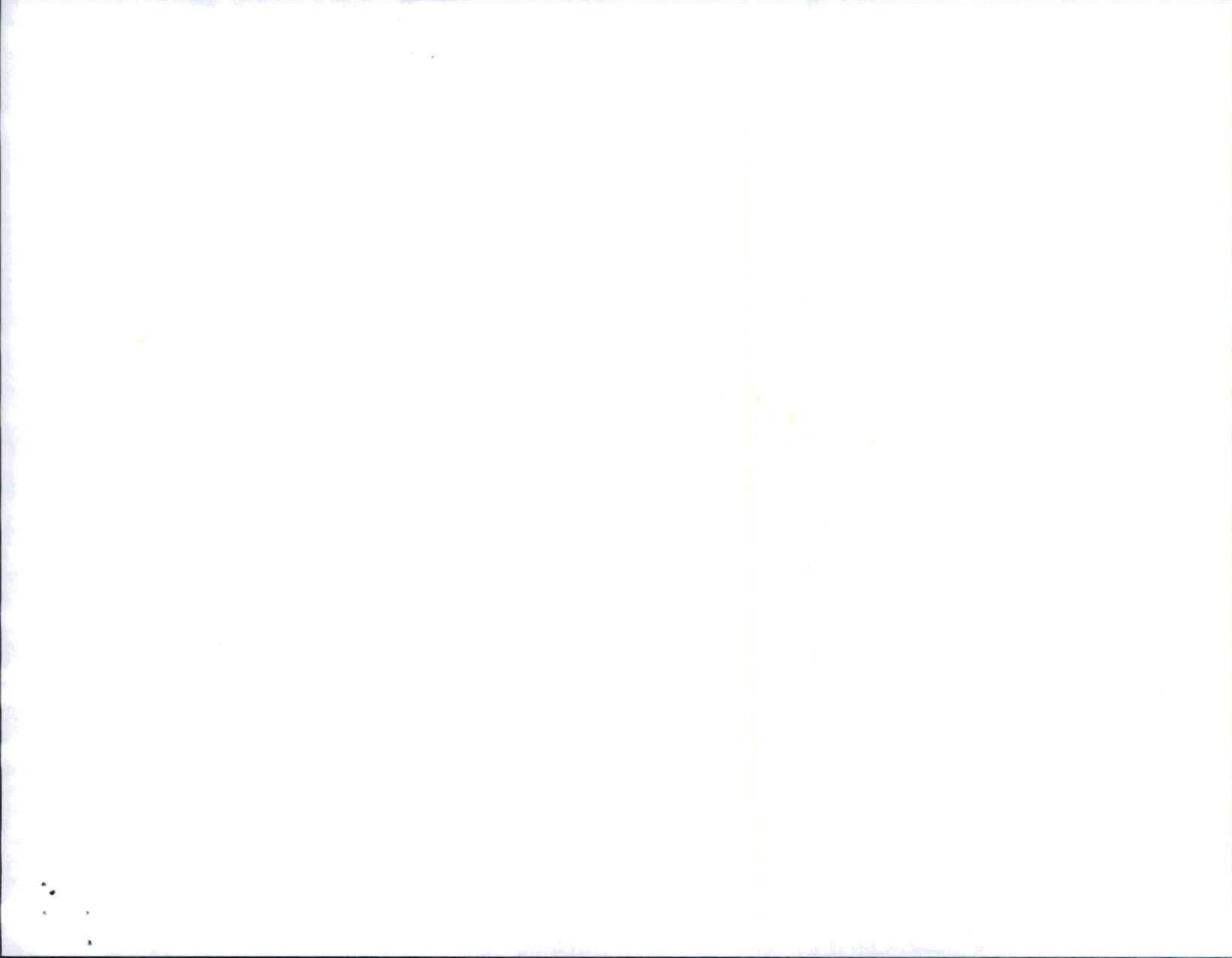
<b>Order No</b> 324283	<b>Line No</b> 1	<b>Item No</b> 6879.MO	<b>Description</b> 2.5000.PL.7075.T7351.ALUMINUM.48.5000.144.5000 CUT 2SIDED TO 8.25 IN ( + .0310/- .0000 IN (GRAIN TO RUN ALONG 5")) X 5 IN ( + .0310/- .0000 IN (GRAIN TO RUN ALONG 5")) - ALUMINUM PLATE SAW			
<b>Purchase Order No</b> 8393		<b>Part Number</b>	<b>Ordered Qty</b> 40 PCS	<b>Invoice Qty</b> 40 PCS	<b>Backorder Qty</b>	
<b>Details</b>		R2C SEE FRANCE STATUS				
<b>Mill</b>	<b>Heat Number</b> 407241	<b>Mech Id</b>	<b>PCS</b> 40	<b>Width (IN)</b>	<b>Length (IN)</b>	<b>Shipped Qty (LBS)</b> 416.7

These commodities/technologies are subject to US Export Administration & US State Dept. Regulations and, if intended for export, were/are exported thereunder. Diversion contrary to US Law is Prohibited.

We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit.

This material has been received and inspected by:

Date:





# CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA

DAVENPORT WORKS

Ship From:

RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

*Malcolm Murphy*

Malcolm Murphy  
Director of Manufacturing Davenport Works

*Kenyon P. Young*

Kenyon P. Young  
Quality Assurance Manager

993938	0	Invoice No.	Alcoa No.	Item	Page
Ship Date	B.L. No.				
2009-01-10	3286081	00000	1000062308-1		1
P.O. No./Govt Contract No.	Customer	Alcoa Item	Mfg Order		
01-16543	CASTLE A M	G041005634R08	DS-62308-1		

Ship To: A M CASTLE & COMPANY  
3400 NORTH WOLF ROAD  
BAY #6  
FRANKLIN PARK 60131 IL

## Item Description

2.5 IN TK (+.0750 -.0750) X 48.5 IN W (+.3125 - 0.000) X 144.5 IN LN (+.5 -0.0) CAT D 164168 (N) A/T 7075-  
T7351 RECTANGLE MILL FINISH, USI 3MM DEAD ZONE REQ'D BOTH SIDES,  
SAWED IAC 6879. EXC MRK A97075-60 REV 22 AMS-QQ-A-250/12 IS 2007 AMS-  
STD-2154 EXC MRK AMS4078 REV G EXC MRK ASTM209  
REV 07 ASTM594 REV 06 BSS7055 REV A  
EXC MRK MMS159 REV N PS21212 REV K ((MARKED))  
KRAFT PAPER INTERLEAVED  
MAX GROSS SKID WGT: 4500 LB QUAN TOL +/-  
25 % USI CL A 3 MM CQR 0137890 REV 17 CUST REQ 09-01-  
10 \*\*\* W/S 09-01-17 \*\*\*

Num	Package Ticket	Lot	Weight	Quantity	UOM	Pc Id/Serl
1	709661	407241	3570	2	PC	:

Notes for CQR: 0137890.17

PRODUCT PRODUCED TO THE REQUIREMENTS OF ASTM2375 ALSO MEET THE REQUIREMENTS OF AMS-STD-2154. PRODUCT PRODUCED TO THE REQUIREMENTS OF AMS-STD-2154 ALSO MEET THE REQUIREMENTS OF ASTM2375.  
THIS MATERIAL HAS BEEN ULTRASONICALLY INSPECTED FULLY IMMERSION - TYPE I.  
PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/12 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/12F. PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/12 F ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/12.  
Exception to Spec A97075-60 ; Revisn: 22 Issue: Letter dated 2007-05-14 from AMERN, DENNIS T to PLATTER, BARE .

CQR: 0137890.17 -Specification Limits

Temp	Dir	UTS	TYS	EL4D											
		KSI	KSI	PCT											
T7351	Long Transv.	Max	63.9												
		Min	66.0	52.0	6										
T7351	Elec. Cond. (RC)	% MIN 38.0 PCT													
Chemical Composition					SI	FE	CU	MN	MG	CR	ZN	TI	Each	Other	Aluminum
Max					0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.15	
Min							1.2		2.1	0.18	5.1			REMAIN	

JAN-14-2009 10:56

AM CASTLE-METALS

B414008521

F.U.13



# CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS  
Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with and has been found to meet the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

*24*

Michael Murphy  
Director of Manufacturing Davenport Works

*Kenton P. Young*

Kenton P. Young  
Quality Assurance Manager

993938	D	Invoice No.	Alcoa No.	Item	Page 2
Ship Date	B.I. No.	00000	1000062308-1		
2009-01-10	3286081	Customer	Alcoa Item	Mfg Order	
P.O. No./Govt Contract No.		CASTLE A N	G041005634R08	DS-62308-1	
01-16543					

CQR: 0137890.17 - Specification Limits (cont.)  
Lot: 407241 - Mechanical, Physical, Metallography, Quantometer Results

Temp	Dir	No->	UTS	TS	ELAD
		Test	KSI	KSI	PCT
T7351	Long Transv.	3	70	58.4	10.3
			69.8	58.2	10.4
			70	58.4	10.4

T7351 Elect Cond %IACS 40.3 40.4 40.5 PCT

Cast Number	Chemical - OBS	SI	FE	CU	MN	MG	CR	ZN	TI
H9127043	Actuals	0.06	0.29	1.6	0.02	2.5	0.19	5.7	0.02

This material was melted in the United States or a Qualifying Country [REF DPARS 225.872.1(a)]; it was manufactured in the United States

*on*

CASTLE METALS CORP.  
DATE RCVD 11-11-09  
IAC 6829  
APPROVED BY *[Signature]*

JAN-14-2009 10:56

AM CASTLE METALS

0414000021

1.0000

